

# SERVICE BULLETIN

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**TITLE: FUEL - INTRODUCTION OF IMPROVED FUEL CELL GASKET**

## 1. Planning Information

### A. Effectivity

(1) Airplanes

Model C90A(C90B), C90GT, C90GTi, (C90GTx), King Air, Serials LJ-1599 through LJ-2003;

Model B200, Super King Air, Serials BB-1735 through BB-2016;

Model B200C, Super King Air, Serials BL-141 through BL-165;

Model B200GT, Super King Air, Serials BY-1 through BY-113;

Model B300(350)(350i)(350ER), Super King Air, Serials FL-284 through FL-741;

Model B300C(350C)(350CER), Super King Air, Serials FM-11 through FM-46.

(2) Spares

The following models and serials that have installed gasket P/N 50-921587-7 as a spare part:

All King Air Models: All Serials;

Models 99, 99A, A99, A99A and B99, Airliner, Serials U-1 through U-49 and U-51 through U-164;

Model C99, Airliner, Serials U-50 and U-165 through U-239;

Model 1900 Airliner, Serial UA-3;

Model 1900C Airliner, UB-1 through UB-74.

If you are no longer in possession of the airplane, please forward this information to the present owner.

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The export of these commodities, technology or software are subject to the U.S. Export Administration Regulations. Diversion contrary to U.S. law is prohibited. For guidance on export control requirements, contact the Commerce Department's Bureau of Export Administration at <http://www.bis.doc.gov>.

Hawker Beechcraft Corporation (HBC) issues Service Information for the benefit of owners and fixed base operators in the form of two classes of Service Bulletins. The first class, Mandatory Service Bulletins (red border) includes changes, inspection and modifications that could affect safety or crashworthiness. HBC also issues Service Bulletins with no red border which are designated as either recommended or optional in the compliance section within the bulletin. In the case of recommended Service Bulletins, HBC feels the changes, modifications, improvements or inspections will benefit the owner/operator and although highly recommended, Recommended Service Bulletins are not considered mandatory at the time of issuance. In the case of Optional Service Bulletins, compliance with the changes, modifications, improvements or inspections is at the owner/operator's discretion.

Both classes are available on the web at <http://pubs.hawkerbeechcraft.com> and mailed to:

- (a) Owners of record on the FAA Aircraft Registration Branch List and the HBC Safety of Flight Information (SOFI) List.
- (b) Those having a publications subscription.

Information on Safety of Flight Information (SOFI) or subscription can be obtained through the Hawker Beechcraft Corporation Technical Manual Distribution Center (TMDC). As Mandatory Service Bulletins and Service Bulletins are issued, the Service Bulletin Master Index will be updated and available online at <http://pubs.hawkerbeechcraft.com>. Warranty will be allowed only when specifically defined in the Service Bulletin and in accordance with HBC Warranty Policy.

Unless otherwise designated, HBC Mandatory Service Bulletins, Service Bulletins and HBC Kits are approved for installation on HBC airplanes in original or HBC modified configurations only. HBC Mandatory Service Bulletins, Service Bulletins and Kits may not be compatible with airplanes modified by STC installations or modifications other than HBC approved kits.

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## **B. Reason**

This Service Bulletin is being issued to install a more moisture-resistant gasket for use on the fuel cell covers.

## **C. Description**

This Service Bulletin announces a fluorosilicone rubber gasket, P/N 50-921587-9, which replaces gasket P/N 50-921587-7.

## **D. Compliance**

### (1) Civil Airplanes

Hawker Beechcraft Corporation recommends that this Service Bulletin be accomplished within the next 400 flight hours, but no later than six (6) calendar months, whichever occurs first.

### (2) Military Airplanes

For compliance information on military airplanes affected by this Service Bulletin, contact the appropriate headquarters.

## **E. Approval**

The engineering data contained in this Service Bulletin is FAA approved.

This modification is classified Minor per FAA Order 8110.52.

Prior to accomplishment, owners/operators of airplanes registered in countries other than the United States shall consult with their local Aviation Regulatory Authority.

## **F. Manpower**

The following information is for planning purposes only:

Estimated man-hours for Model 90/F90/99/100/1900 series: 2 hours per fuel cell / 4 hours total

Estimated man-hours for Model 200/300/B300 series: 2 hours per fuel cell / 8 hours total

Estimated additional man-hours for removal/replacement of extended range fuel tanks on Model B300 series with extended range fuel tanks only: 3 hours per extended range fuel tank / 6 hours total

Suggested number of technicians: 2

The above is an estimate based on experienced, properly equipped technicians complying with this Service Bulletin.

## **G. Weight and Balance**

Negligible.

It is the responsibility of the owner/operator to maintain compliance with the applicable Airworthiness Regulations.

## **H. Electrical Load Data**

No change.

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## **I. Software Accomplishment Summary**

Not applicable.

## **J. References**

Appropriate chapter of the model applicable:

Maintenance Manual (MM);

Maintenance Manual Supplement (MMS);

Structural Inspection and Repair Manual (SIRM);

Structural Inspection Manual (SIM);

Structural Repair Manual (SRM);

Model 1900 Airliner Series Corrosion Control Manual (CCM);

Illustrated Parts Catalog (IPC).

## **K. Publications Affected**

It is recommended that a note "See Service Bulletin 28-4059" be made in the following:

Appropriate chapter of the model applicable Illustrated Parts Catalog (IPC).

## **L. Interchangeability of Parts**

Not applicable.

## **M. Warranty Credit**

### (1) Civil Airplanes

Warranty credit for labor and parts to the extent noted under MANPOWER and MATERIAL will be allowed on all airplanes that are under Standard Warranty coverage on the date of issuance of this Service Bulletin. Credit will be given for any airplanes that have an active HBC Maintenance Program for labor and parts, if coverage is active and the work is accomplished prior to the warranty expiration date listed in this Service Bulletin. Claims for compliance with this Service Bulletin are to be filed as a W4-type claim against SB 28-4059.

Warranty coverage offered in this Service Bulletin will expire six (6) months from the last day of the month this Service Bulletin is issued. After this date, the owner/operator assumes the responsibility for compliance cost. Hawker Beechcraft Corporation (HBC) reserves the right to void continued warranty coverage in the area affected by this Service Bulletin until the date the Service Bulletin is accomplished by an HBC Authorized Service Center (ASC).

The owner/operator should contact an HBC ASC to schedule the warranty work to be accomplished. The HBC ASC must be rated to perform maintenance on the specific model of Hawker Beechcraft airplane. The HBC ASC will submit the appropriate paperwork directly to the HBC Warranty Department for warranty consideration. After the Service Bulletin has been accomplished, a warranty claim must be submitted to HBC within 60 days of the Service Bulletin completion date.

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The unused spare P/N 50-921587-7 gaskets should be red-tagged and returned, along with the Return Authorization Form, to the following address in order to receive warranty credit:

Hawker Beechcraft Parts & Distribution (HBP&D)  
Attn: Warranty Hold Area  
370 N. Webb Rd., East Dock, Bldg 66  
Wichita, KS 67206

### NOTE

Warranty credit for spares stock of P/N 50-921587-7 gasket should be filed as a W4-type claim. When submitting for spares warranty online, specify NONHBC as airplane serial number and "1" for airplane hours and part hours.

(2) Military Airplanes

For warranty information on military airplanes affected by this Service Bulletin, contact the appropriate headquarters.

## 2. Material Information

### A. Materials - Price and Availability

Contact information:

Hawker Beechcraft Parts & Distribution (HBP&D)  
10511 East Central Avenue  
Wichita, KS 67206  
USA  
Phone: 316-676-3100 or 1-888-727-4344  
Fax: 316-676-3222 or 316-676-3327  
E-mail: HBC\_Parts@hawkerbeechcraft.com

### B. Industry Support

Not applicable.

### C. Airplanes

The following parts required for accomplishment of this Service Bulletin may be ordered through a Hawker Beechcraft Authorized Service Center or HBP&D:

Part Number	Description	Quantity Per Airplane
50-921587-9	Gasket, Rubber	2 per fuel cell
MS35333-40	Locktooth Washer	36 per fuel cell

Hawker Beechcraft Corporation expressly reserves the right to supersede, cancel and/or declare obsolete, without prior notice, any parts or publications that may be referenced in this Service Bulletin.

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## D. Spares

Gasket P/N 50-921587-9.

## E. Reidentified Parts

None.

## F. Tooling - Price and Availability

None.

### 3. Accomplishment Instructions

This Service Bulletin shall be accomplished as follows:

#### NOTE

Should any difficulty be encountered in accomplishing this Service Bulletin, contact Hawker Beechcraft Corporation at 1-800-429-5372 or 316-676-3140. Contact appropriate headquarters for military airplanes.

<b>WARNING</b>
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**Observe all Warnings and Cautions contained in the airplane manuals referenced in this Service Bulletin.**

**Whenever any part of this system is dismantled, adjusted, repaired or renewed, detailed investigation must be made on completion to make sure that distortion, tools, rags or any other loose articles or foreign matter that could impede the free movement and safe operation of the system are not present, and that the systems and installations in the work area are clean.**

#### A. Airplane

#### NOTE

**If improved P/N 50-921587-9 fuel cell gaskets have been installed on the airplane, then no further action is required.**

- (1) Remove all power from the airplane and disconnect the battery. Display warning notices prohibiting reconnection of airplane electrical power.
- (2) Model 1900 airplanes are not equipped with nacelle fuel cells. Proceed to procedures for center wing fuel cells in Step (15).

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## *Nacelle Fuel Cells*

**WARNING**

**Review Warnings and Cautions pertaining to refueling, defueling, purging, and fuel handling in the airplane maintenance manual prior to beginning work.**

**NOTE**

Procedures apply to both left and right nacelle fuel cells.

- (3) If required, remove the extended range fuel tanks for access. Refer to MMS, Chapter 28-20-00.
- (4) Drain and purge the nacelle fuel cell.
- (5) Remove access panel on top of nacelle.
- (6) Disconnect plumbing and electrical wiring as necessary to access fuel cell. Refer to applicable MM, Chapter 28-40-00.
- (7) Remove the 36 bolts securing the fuel cell cover. Retain bolts and flat washers. Discard all locktooth washers. Refer to Figure 1.
- (8) Remove nacelle fuel cell cover assembly.
- (9) Remove and discard two (2) gaskets per nacelle; one under fuel cell cover, the other on top of fuel cell liner.

**NOTE**

**Inspect adjacent areas for damage, wear, or corrosion and treat as necessary. Refer to model applicable Structural Inspection/Repair Manual.**

- (10) Install new P/N 50-921587-9 gaskets; two (2) per nacelle. Refer to Figure 1, View C-C for proper placement.
- (11) Install cover assembly with retained bolts:
  - (a) Ensure all holes are aligned with fuel liner nuts prior to insertion of bolts.

**CAUTION**

*Do not catch threads of bolts on edges of gasket during insertion.*

**NOTE**

It is important to tighten access panels in a definite pattern to ensure uniform compression of seals and prevent possible fuel seepage. When securing the panel, initially snug the screws in the defined sequence, then tighten the screws in the same sequence. Refer to Figure 1, Detail B.

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- (b) Install bolts, new P/N MS35333-40 locktooth washers, and retained P/N AN960-416L flat washers (flat washer against cover).
- (c) Torque bolts to 35 to 40 inch-pounds in the sequence shown.
- (d) Check torque in sequence shown and re-torque bolt **only** if torque is lower than 30 inch-pounds.
- (12) Install plumbing and electrical wiring removed in Step (6) to access fuel cell. Refer to applicable MM, Chapter 28-40-00.
- (13) Repeat fuel cell gasket replacement procedure on opposite nacelle fuel cell.
- (14) If airplane is equipped with auxiliary or center wing fuel cells, proceed to Step (15). If not, proceed to Step (25).

### *Auxiliary or Center Wing Fuel Cells*

**WARNING**

**Review Warnings and Cautions pertaining to refueling, defueling, purging, and fuel handling in the airplane maintenance manual prior to beginning work.**

**NOTE**

Procedures apply to both left and right auxiliary/wing fuel cells. Model 1900 airplanes are equipped with center wing fuel cell covers only.

- (15) Drain and purge the auxiliary/center wing fuel cell.
- (16) Remove access panel on top of inboard wing.
- (17) Disconnect plumbing and electrical wiring as necessary to access fuel cell. Refer to applicable MM, Chapter 28-40-00.
- (18) Remove the 36 bolts securing the fuel cell cover. Retain bolts and flat washers. Discard all locktooth washers. Refer to Figure 1.
- (19) Remove fuel cell cover assembly.
- (20) Remove and discard two (2) gaskets per fuel cell; one under fuel cell cover, the other on top of fuel cell liner.

**NOTE**

**Inspect adjacent areas for damage, wear, or corrosion and treat as necessary. Refer to model applicable Structural Inspection/Repair Manual.**

- (21) Install new P/N 50-921587-9 gaskets; two (2) per fuel cell. Refer to Figure 1, View C-C for proper placement.

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- (22) Install cover assembly with retained bolts:
- (a) Ensure all holes are aligned with fuel liner nuts prior to insertion of bolts.

**CAUTION**

*Do not catch threads of bolts on edges of gasket during insertion.*

**NOTE**

It is important to tighten access panels in a definite pattern to ensure uniform compression of seals and prevent possible fuel seepage. When securing the panel, initially snug the screws in the defined sequence, then tighten the screws in the same sequence. Refer to Figure 1, Detail B.

- (b) Install bolts, new P/N MS35333-40 locktooth washers, and retained P/N AN960-416L flat washers (flat washer against cover).
- (c) Torque bolts to 35 to 40 inch-pounds in the sequence shown.
- (d) Check torque in sequence shown and re-torque bolt **only** if torque is lower than 30 inch-pounds.
- (23) Install plumbing and electrical wiring removed in Step (17) to access fuel cell. Refer to applicable MM, Chapter 28-40-00.
- (24) Repeat gasket replacement procedure on opposite auxiliary/wing fuel cell.
- (25) If required, install the extended range fuel tanks removed in Step (3) for access. Refer to MMS, Chapter 28-20-00.
- (26) Reconnect the airplane battery, remove warning notices, and restore power.
- (27) Refuel the airplane.
- (28) Check for leakage at plumbing that was disconnected.
- (29) Install access panel on top of each nacelle and auxiliary/wing fuel cell.
- (30) Ensure all work areas are clean and clear of tools and miscellaneous items of equipment.
- (31) Return airplane to service.

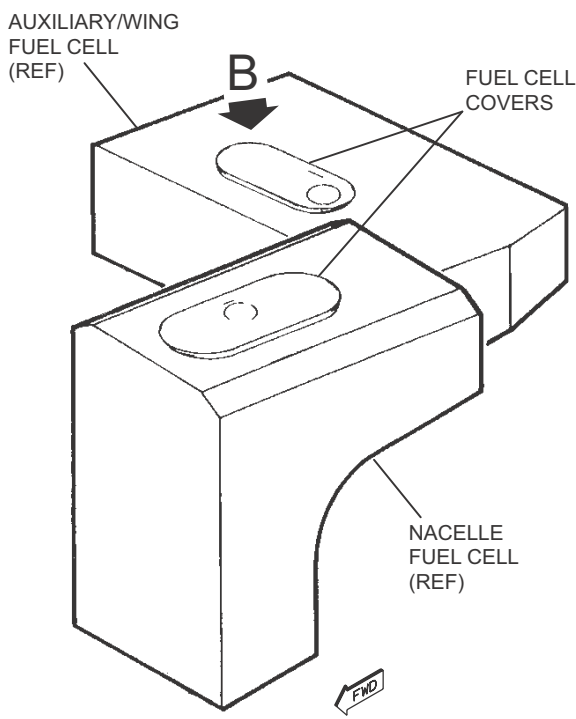
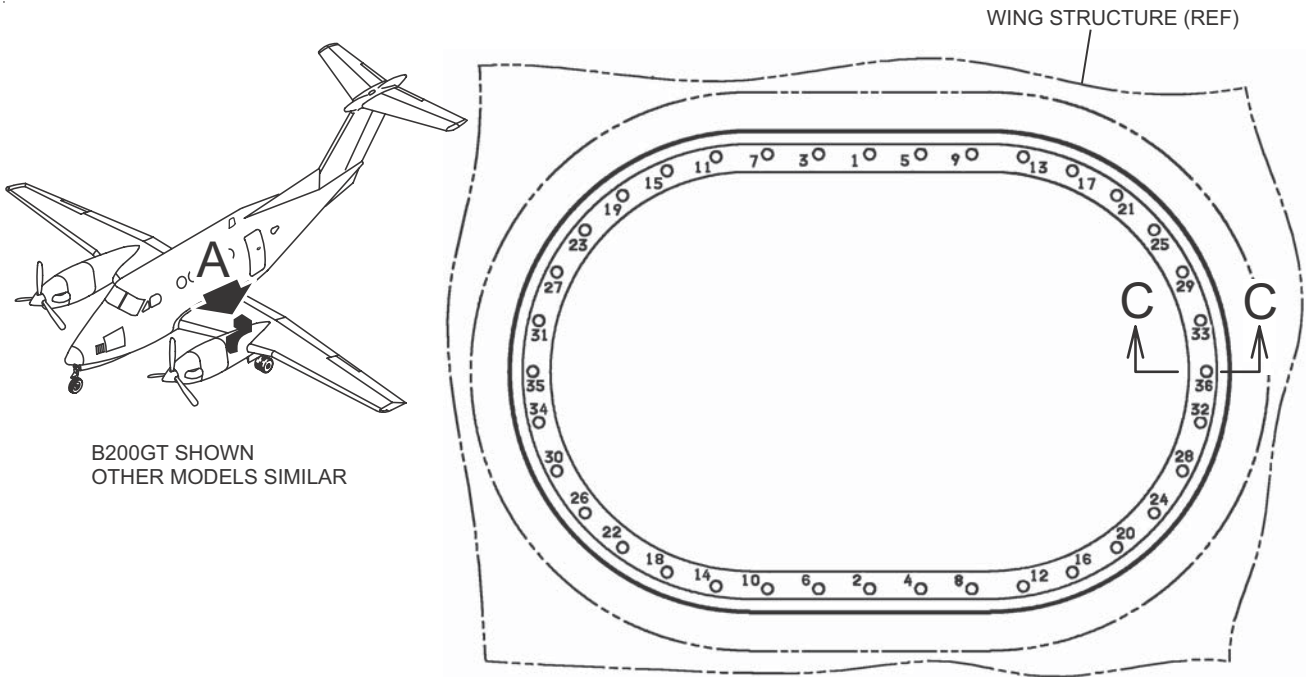
**B. Spares**

Purge stock of gasket P/N 50-921587-7. Refer to Paragraph 1.M. Warranty Credit.

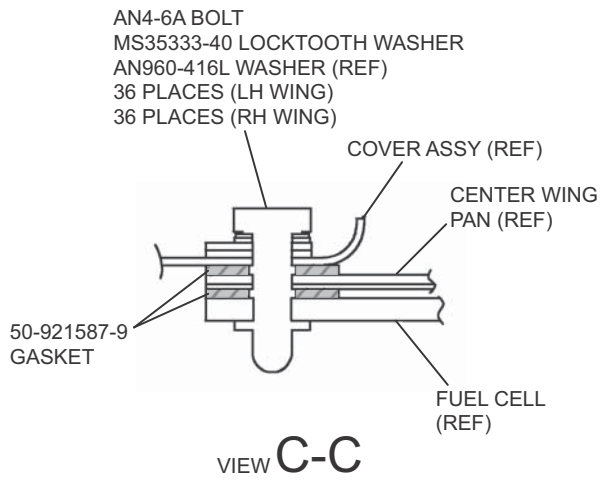
**C. Record of Compliance**

Upon completion of this Service Bulletin, make an appropriate maintenance record entry.

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**DETAIL B**  
AUXILIARY/WING COVER SHOWN  
(NACELLE COVER SIMILAR)



**DETAIL A**  
LEFT SHOWN RIGHT OPPOSITE

**Fuel Cell Gaskets  
Figure 1**

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